

# Work Order ID 59102

Wednesday, May 26, 2010 12:30:19 PM



Page 1

Item ID:	D4035-043	Accept		Setup	Start	
Revision ID:				Stop		
Item Name:	Lid Rib Assembly, Aft (350 Basket)					
Start Date:	5/26/2010	Start Qty:	2.00	Cust Item ID:		
Required Date:	5/31/2010	Req'd Qty:	2.00	Customer:		

Reference:		Run	Start	
Approvals:	Process Plan:	Date: 10-3-26	Tooling:	Date:
QC:		Date:	SPC (Y/N):	Date:
				Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4035	A								

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: 4113328 0.00

## Memo

0.00

- 1- Cut D4035-3 as per dwg D4035
- 2- Drill holes using DT9563 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

SAD 10-06-03

② 10/06/03

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

## Memo

0.00

② 10-06-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 59102**

Wednesday, May 26, 2010 12:30:19 PM



Page 2

Item ID: D4035-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 5/26/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

② PD 10.06.03

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

10/06/03 ②

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/04

MF  
10-6-4

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 26, 2010 12:30:24 PM

Page 1

Work Order ID: 59102

Parent Item: D4035-043

Parent Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 5/26/2010


Required Date: 5/31/2010

Comments: IPP revA: new issue DD 09.11.25 verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4021-9		Manufactured	No			100	Each	28.0000	2	4			
													
Bushing													

*SM 10/06/03*

Location	Loc Qty	Loc Code
WA	28	
56094	2	
58404	10	
58701	16	

M304TS0.750W.049

Purchased

No

100

f

209.6588

1.75

3.684211



304 SQ Tube .75x.75x.049W



*SAD 10-06-03*

Location	Loc Qty	Loc Code
MAT	209.6587789	
113763	0	
114323	33.2519289	
114677	176.40685	
MAT017	3.68448E-05	
114298	3.6845E-05	

*3.6842*

W/O:		WORK ORDER CHANGES					
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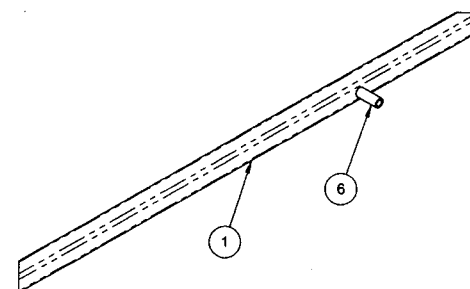
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

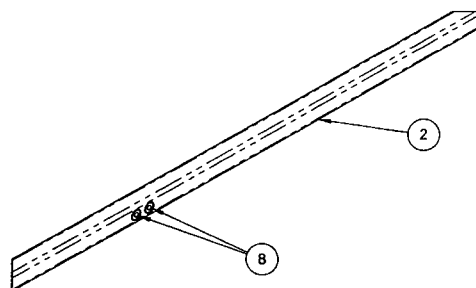
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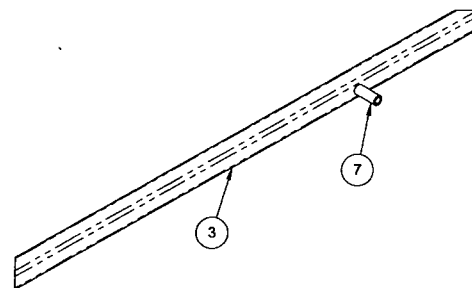
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



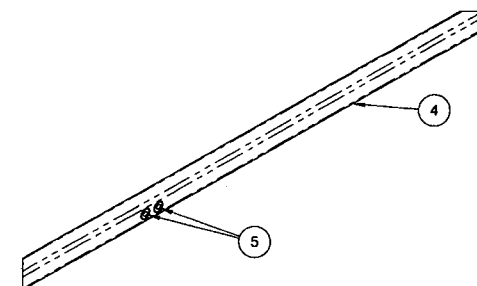
**D4035-041 BASKET LID RIB ASSY, FWD**



**D4035-043 BASKET LID RIB ASSY, AFT**



**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**



**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 59102

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. A
CHECKED		D4035	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID RIB ASSY	NTS
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DATE	10.03.04		

*BS-05-26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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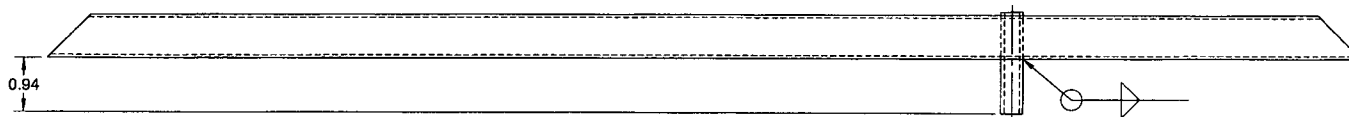
NOTE: Date & initial all entries



8 7 6 5 4 3 2 1

D

D



D4035-1  
RIB

D2327-3  
SPACER BUSHING

**D4035-041 BASKET LID RIB ASSY, FWD**

C

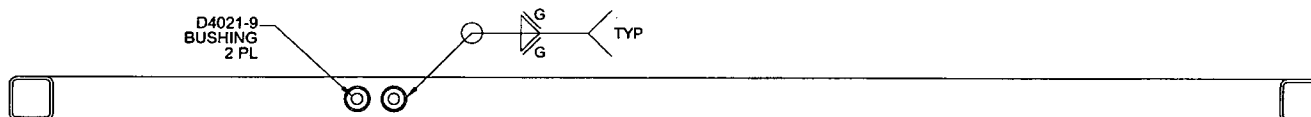
C



D4035-3  
RIB

B

B



D4021-9  
BUSHING  
2 PL

TYP

**D4035-043 BASKET LID RIB ASSY, AFT**

A

A

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

WLO 59102

**RELEASED**  
2010-03-12  
WLO

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
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8 7 6 5 4 3 2 1

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8 7 6 5 4 3 2 1

D4035-5  
RIB

D2953-175  
SPACER

0.94

**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**

D4035-7  
RIB

D4035-11  
BUSHING  
2 PL

G  
G  
TYP




**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12  
NW

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

W059102

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4035	SHEET 3 OF 5
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8 7 6 5 4 3 2 1

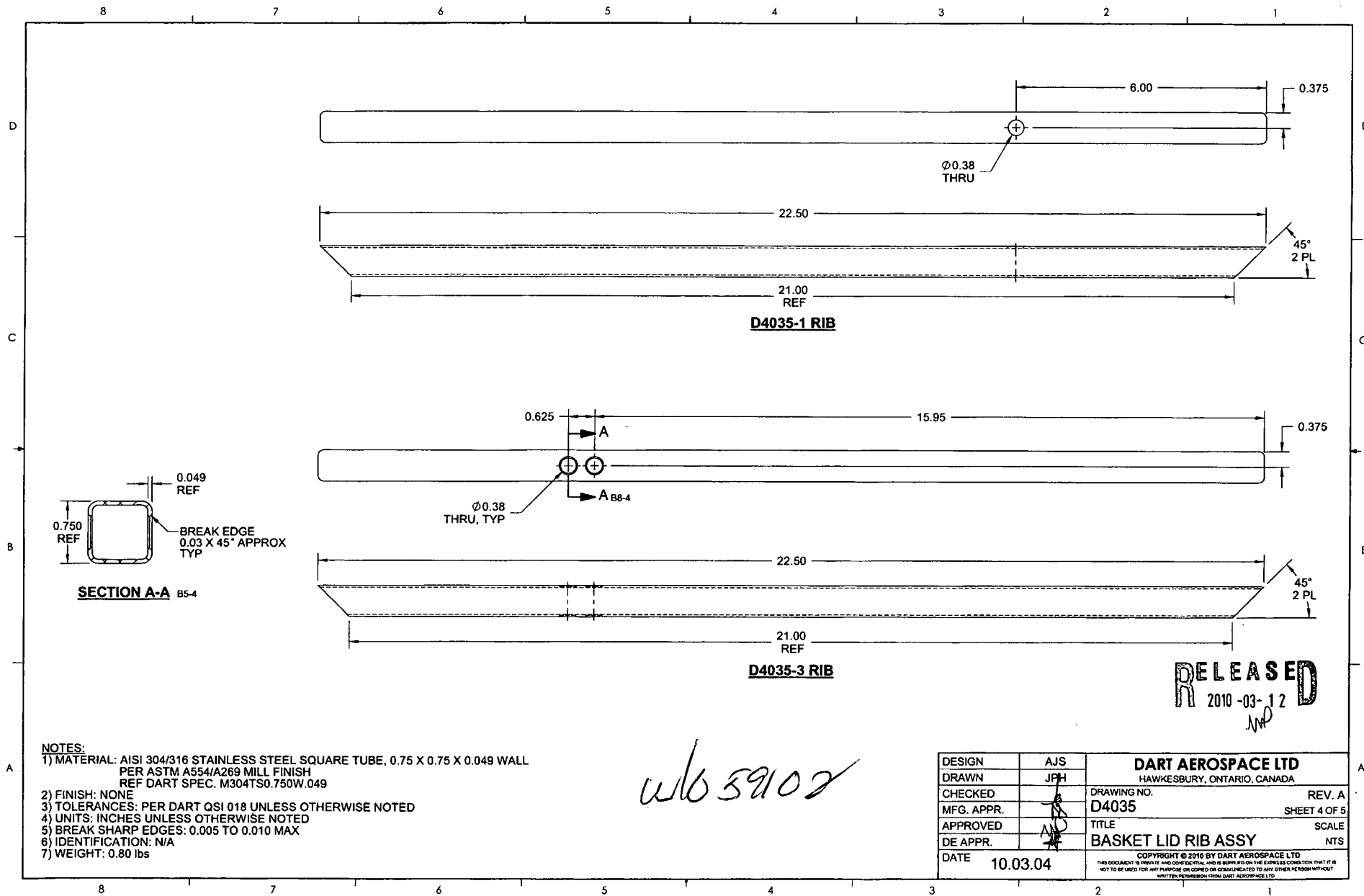
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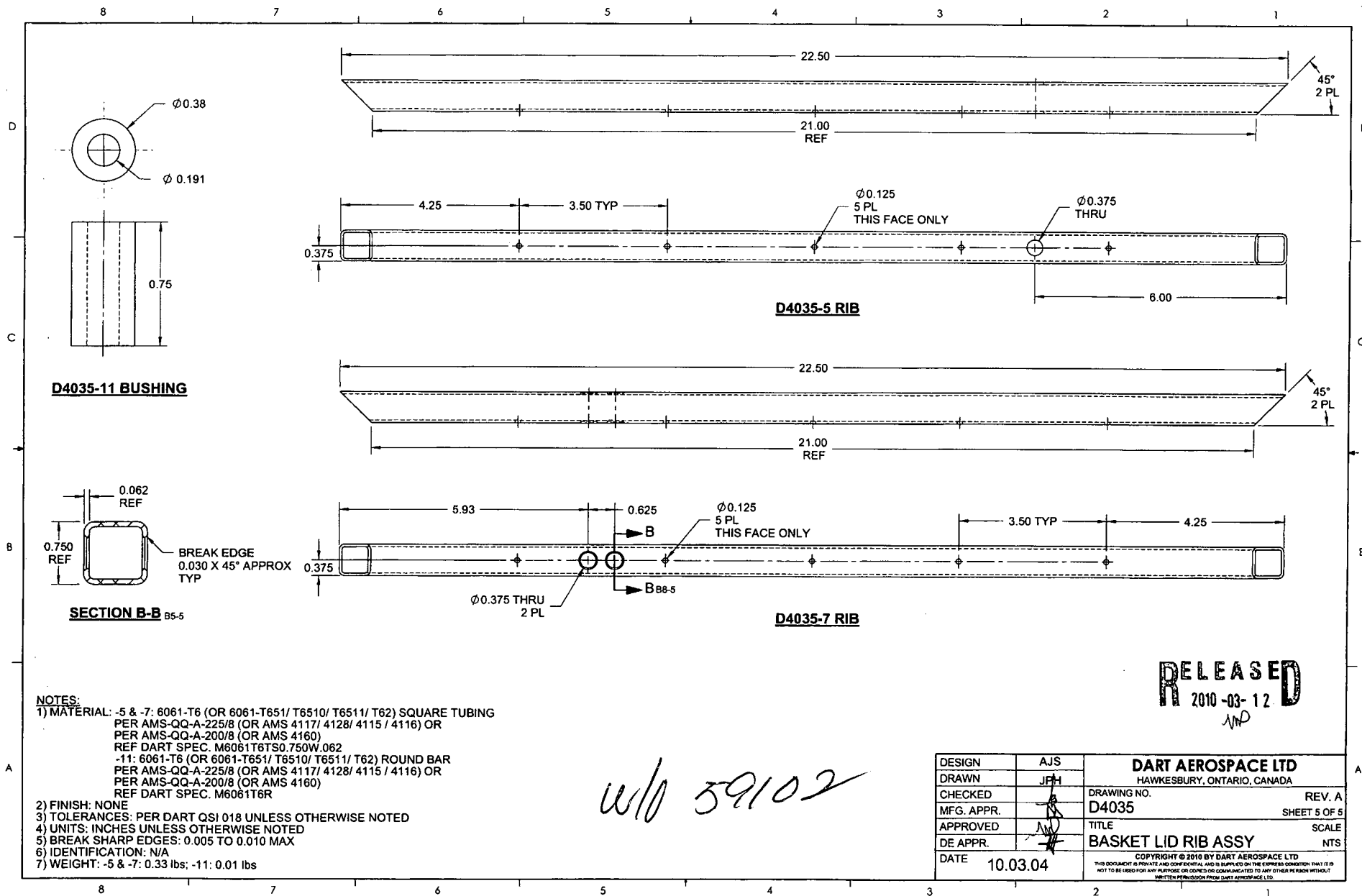
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